

Date: Thursday, 3/30/2006 10:06:10 AM  
 User: Kim Johnston

## Process Sheet

*Split*  
*06/05/02*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY  
 Job Number : 26452 - ( Part Number : D3065041  
 Estimate Number : 10385 Drawing Number : D3065 REV A2  
 P.O. Number : NIA Project Number : N/A  
 This Issue : 3/30/2006 S.O. No. : NIA Drawing Revision : A2  
 Prsht Rev. : NC Material : NIA  
 First Issue : NIA Type : SMALL / MED FAB Due Date : 4/15/2006 Qty: 60 Um: Each  
 Previous Run : 26211  
 Written By : *SEE COMMENT BELOW*  
 Checked & Approved By : *03.30*  
 Comment : Est Rev: 02.11.01 Incorporated D3066-1 IPP KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 26452A STEP SPACER



Comment: Sub-Component STEP SPACER

2.0 26452B STEP SPACER



Comment: Sub-Component STEP SPACER

3.0 26452C STEP LEG



Comment: Sub-Component STEP LEG

4.0 26452D STEP SPACER



Comment: Sub-Component STEP SPACER

5.0 D30651 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-1	Spacer	B26452-A-1

*SB 06/05/04 50*

6.0 D30653 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-3	Spacer	⑦ B22959 ③ B22361

*SB 06/05/04 50*

*B26452B*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 26452

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D30655

Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Leg

Pick:

Qty Part Number

Description

Batch

2 D3065-5

Leg

B26452C

SB 06/05/04

(50)

8.0

D30657

Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Spacer

Pick:

Qty Part Number

Description

Batch

1 D3065-7

Spacer

B26452D-1

SB 06/05/04

50

9.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number

Description

Batch

30 MS20470AD4-4

Rivet

M19073

SB 06/05/04

50

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

SB 06/05/04

(50)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06-05-04

(50)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

NA 19

SB 06/05/04

(50)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 06/05/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 26452

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Handwritten:* D 06/05/05 (50)

Job Completion



*Handwritten:* 4 06-08-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

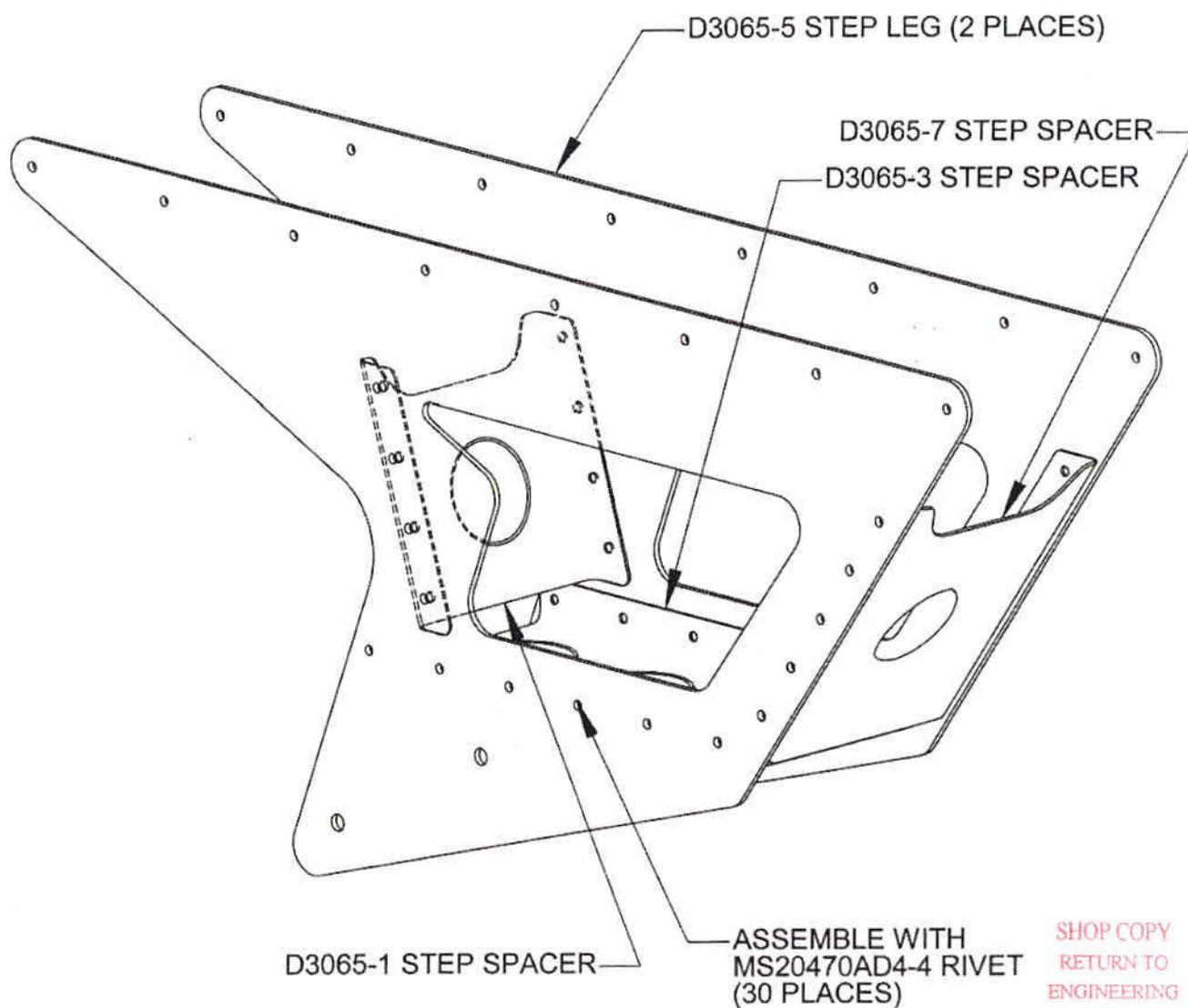
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 <i>CP</i>	ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>	0.551 WAS 0.410	

RELEASED  
02.09.20 *[Signature]*



## D3065-041 STEP LEG ASSEMBLY

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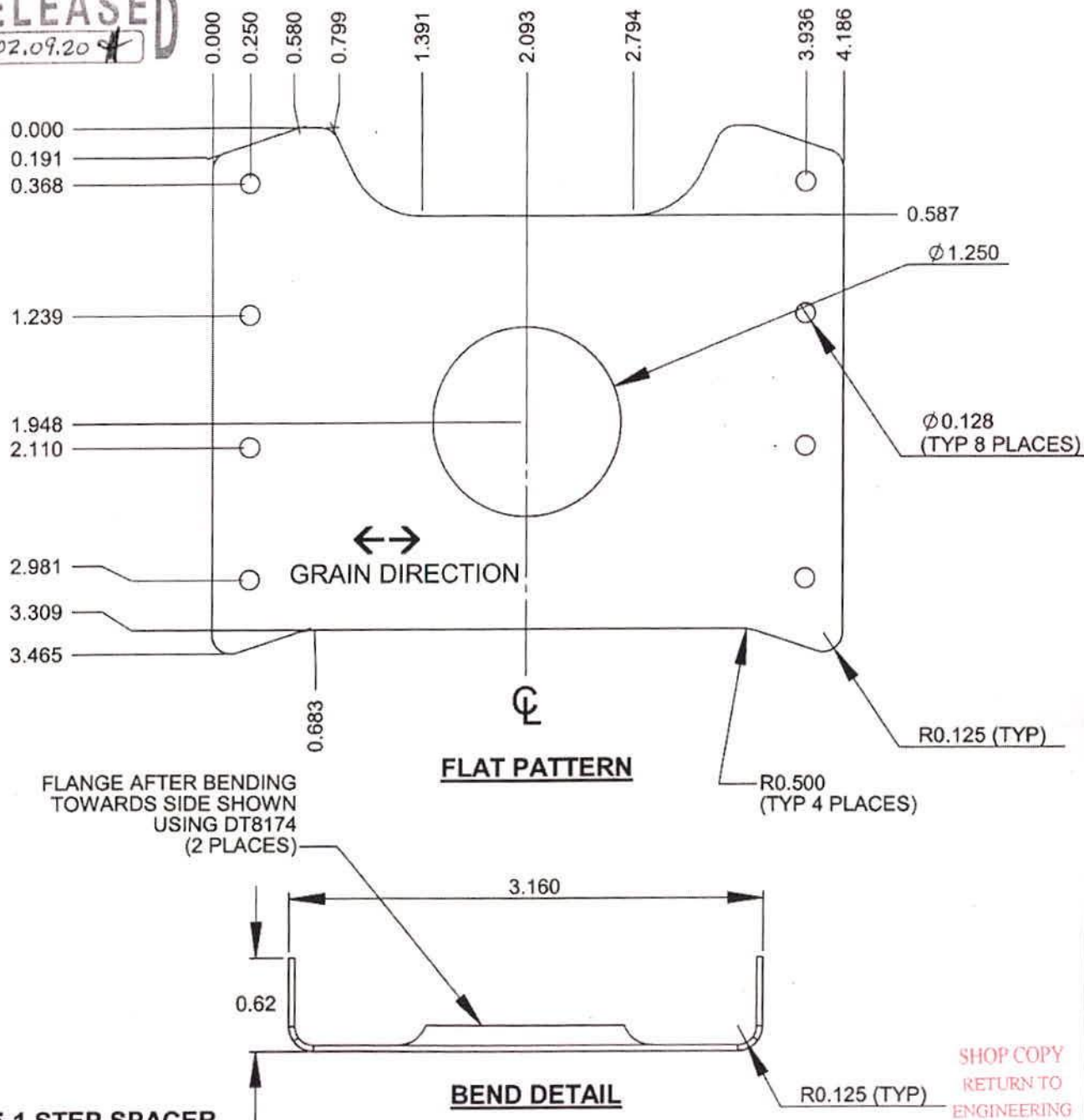
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DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED  
02.09.20 *#*



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 26452

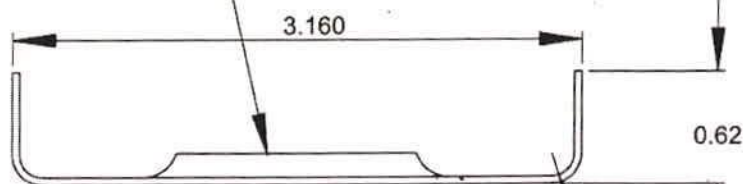
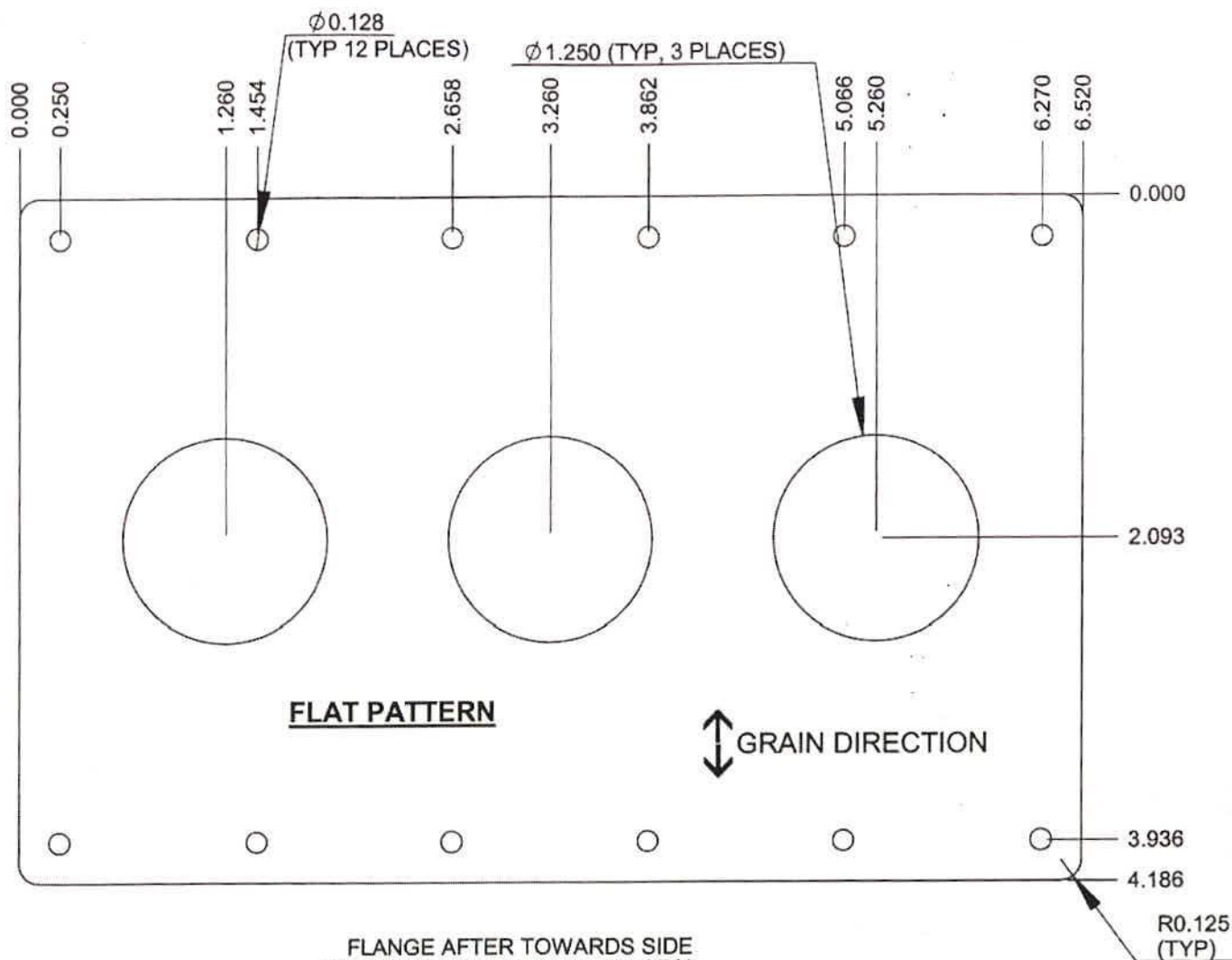


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02.09.20

**DART**



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DATE <b>02.09.11</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1



**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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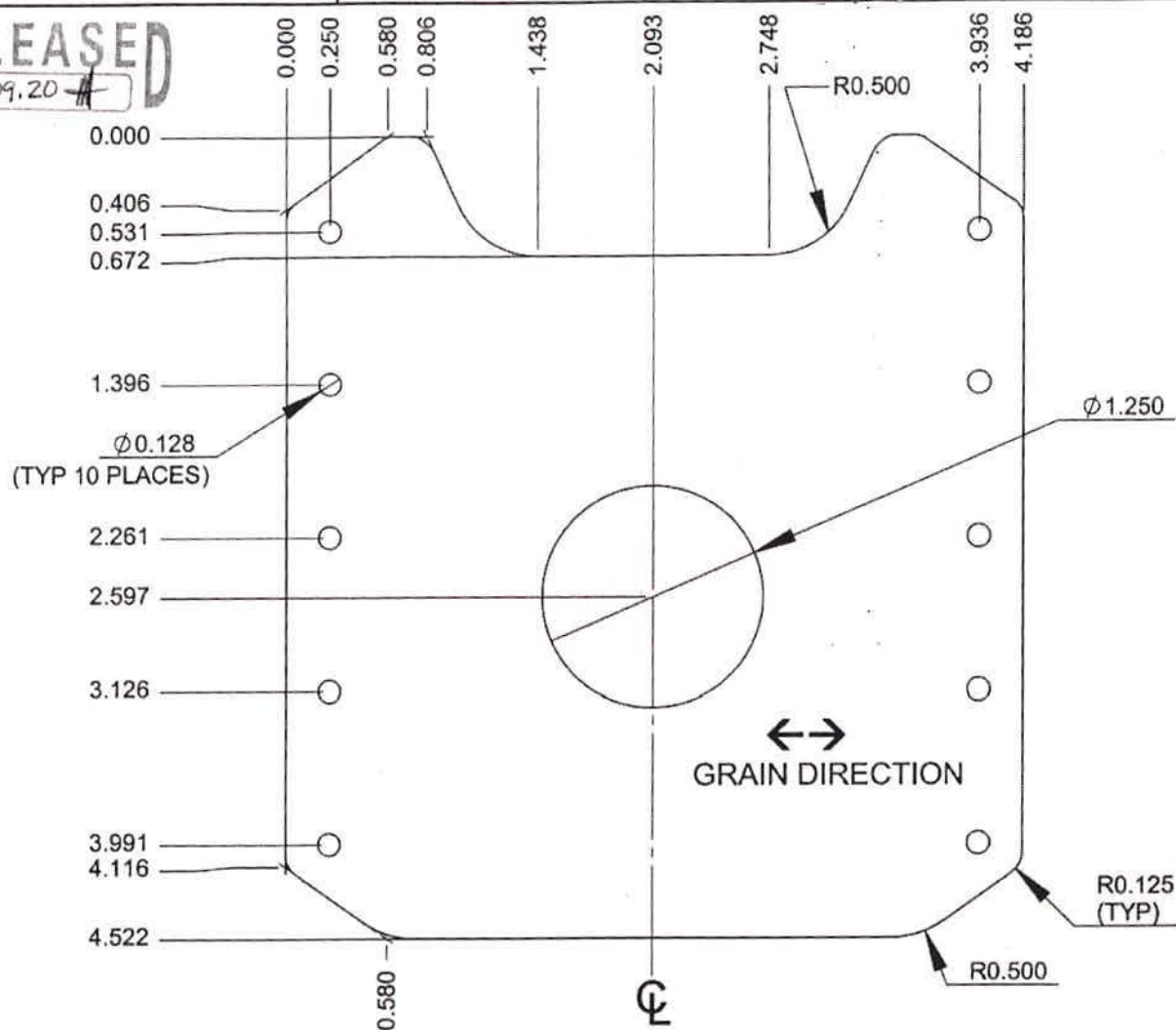
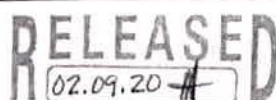
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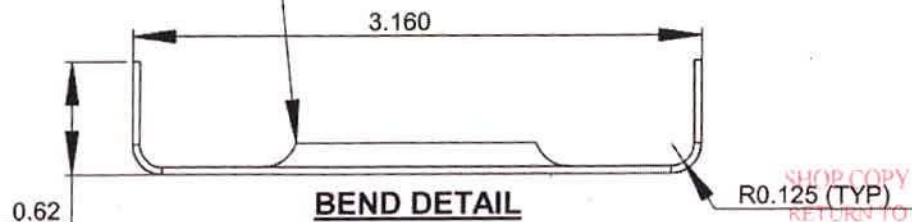


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DATE <b>02.09.11</b>		TITLE <b>STEP LEG ASSEMBLY</b> SCALE 1:1	



FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)

## FLAT PATTERN



### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) PART IS SYMMETRIC ABOUT CENTERLINE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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